

Date: Monday, 02/10/2006 7:16:03 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 28804		Part Number	: D2573		
Estimate Number	: 10533		Drawing Number	: D2573 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 02/10/2006	S.O. No. : N/A	Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 09/10/2006		
Previous Run	: 28446		Qty:	4	Um:	Each
Written By	: <u>  </u>					
Checked & Approved By	: <u>  </u>					
Comment	: Est: 1 As Per RevE 06-01-27 JLM					

## Additional Product

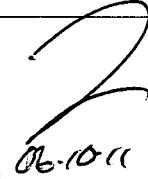
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5 
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)            7075-T7351 8.25X7.75X2.5            Make from D6101-007 billet for D2573            Ensure that grain is along 7.75" length            Batch No: <u>B25354</u></p>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
<p>Comment: HAAS CNC VERTICAL MACHINING #1            Program Batch No <u>28804</u> Double check by: <u>MS</u></p> <p>1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets            2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets            3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets            4-Deburr and remove all machining marks            5-Tumble to remove sharp edges.</p>		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
<p>Comment: CONVENTIONAL MILLING MACHINE            Machine keyway as per dwg D2573 &amp; D2574</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/10/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/03	2	the thickness of the 1.510" BORE is under tolerance by 0.002"	JP 06.10.04 PV QS1042	PART IS OK per attached DS encl.	SG 10.03 06.10.03 06.10.11		UP 66.10.03 PV QS1042	

NOTE: Date & initial all entries

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Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 28804

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G 06/10/04 4

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 06/10/05 x 4

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

06/10/05 x 4

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-10-10

4

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PACKAGING RESOURCE #1



9.0 PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57480

06/10/11 (4)

4

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



06/10/11

4

Job Completion



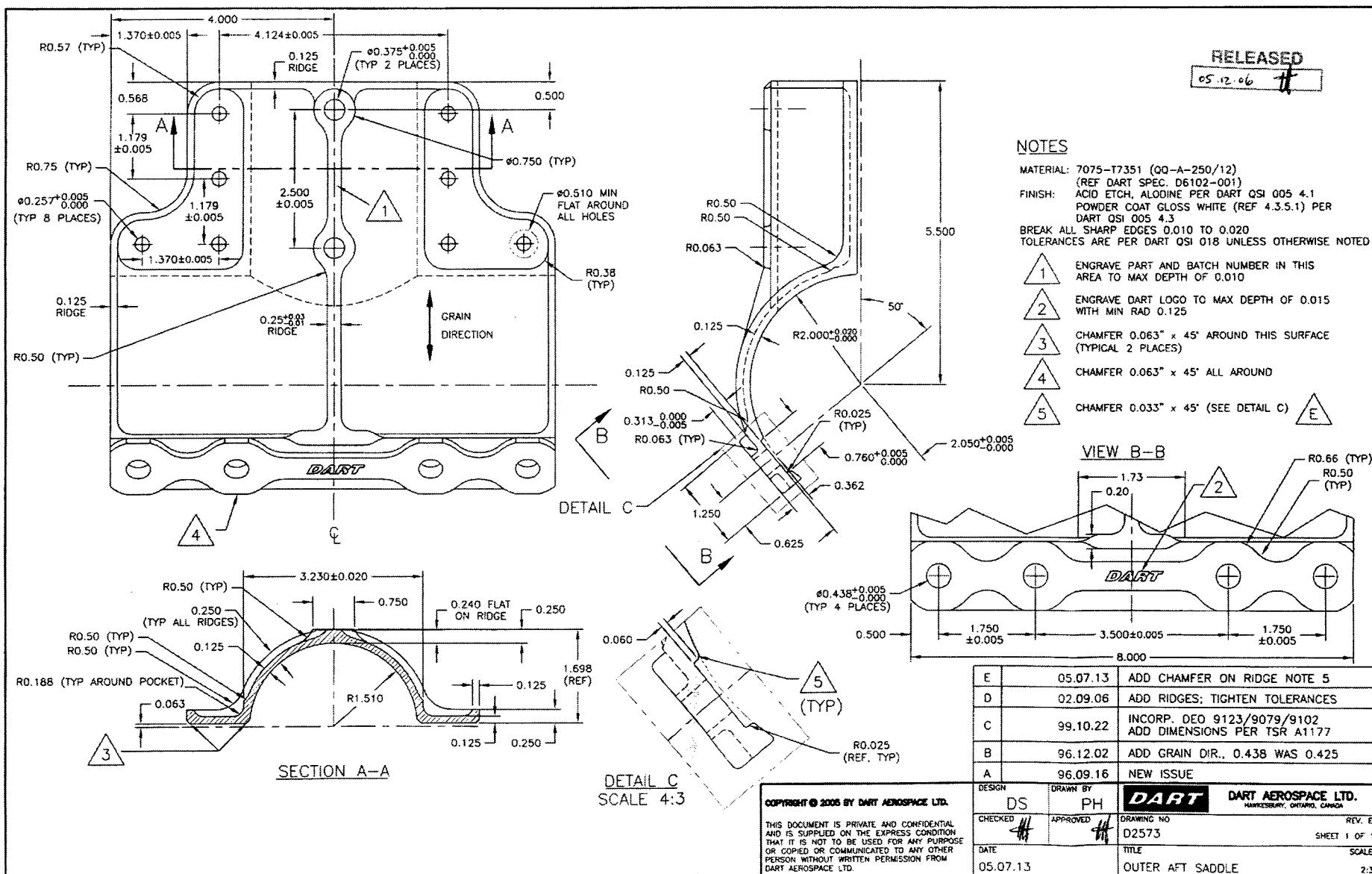
06/10/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

28804

Description: Saddle, Aft Outboard

Part Number:

D2573

Inspection Dwg: D2573 Rev. E

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.751	1.750	1.750	1.751		
C	3.495	3.505		3.501	3.500	3.500	3.501		
D	1.745	1.755		1.751	1.751	1.751	1.751		
E	7.990	8.010		8.004	8.003	8.004	8.004		
F	0.490	0.510		0.501	0.501	0.501	0.501		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.375		
I	0.490	0.510		0.501	0.501	0.502	0.500		
J	1.174	1.184		1.180	1.179	1.179	1.180		
K	0.558	0.578		0.568	0.569	0.567	0.569		
L	1.174	1.184		1.179	1.180	1.179	1.180		
M	1.365	1.375		1.369	1.369	1.370	1.369		
N	2.495	2.505		2.499	2.499	2.498	2.499		
O	4.119	4.129		4.122	4.121	4.122	4.121		
P	0.115	0.135		0.122	0.122	0.124	0.123		
Q	0.115	0.135		0.134	0.134	0.135	0.135		
R	0.240	0.260		0.254	0.254	0.252	0.251		
S	0.115	0.135		0.113	0.119	0.119	0.119		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.231	3.231	3.231		
V	0.230	0.250		0.240	0.241	0.242	0.241		
W	0.115	0.135		0.118	0.119	0.119	0.119		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.365	0.364	0.366	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.629	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.248	0.247	0.246		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.134	0.135	0.134	0.135		
AG	0.240	0.280		0.260	0.260	0.261	0.261		
AH	0.240	0.260		0.255	0.254	0.254	0.254		
AI	2.000	2.020		2.000	2.001	2.001	2.002		
AJ	0.023	0.043		0.033	0.083	0.063	0.063		
Accept/Reject									

Measured by: J. G  
 Date: 06/10/03

Audited by: E  
 Date: 06/10/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

## Chris Provencal

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** October 4, 2006 3:56 PM  
**To:** 'Chris Provencal'  
**Subject:** RE: ncr D2573 saddle

I think this is an acceptable deviation.

David

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**From:** Chris Provencal [mailto:cprovencal@dartaero.com]  
**Sent:** Wednesday, October 04, 2006 11:34 AM  
**To:** David Shepherd (David Shepherd)  
**Subject:** ncr D2573 saddle

David,

One D2573 saddle. The wall thickness of the saddle-to-crosstube bore is 0.113" instead of 0.125"+/-0.010". I looked through SR-D205-634, and I can't find anything that analyzes through that section, seems to be done with ansys, but I figure you've probably encountered that before. Is this acceptable?

Chris

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No virus found in this incoming message.  
Checked by AVG Free Edition.  
Version: 7.1.407 / Virus Database: 268.12.12/462 - Release Date: 10/3/2006

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